

5/12

DART AEROSPACE LTD	Work Order:	22381
Description: Plug	Part Number:	D2594-1
Dwg: D2594 Rev. B1	Qty:	500
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JF	05.02.08	500
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	M16807 M15138 Batch A42446		
3	MC	Break all sharp edges 0.010 max.	M15709	EP	05/02/14 500
4A	QC2	Inspect dimensions as per drawing D2594	EP	05/02/15	500
4B	QC8	Second check	DR	05/02/15	500
5	FP	Acid etch and alodine as per QSI 005 4.1	M	05.02.16	500
6	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	FF	05/05/15	500
7	QC3	Inspect Powder Coat	M	05.05.09	500
8	FP	Identify and Stock	M	05.05.09	500
9	AC	Cost / part , 69	SUR	05.05.10	500
10	DC	Close W/O , 69 Inspect Level 21	JF	05.05.10	500

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ RF	

RELEASED
02/08/22 RF

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22381
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

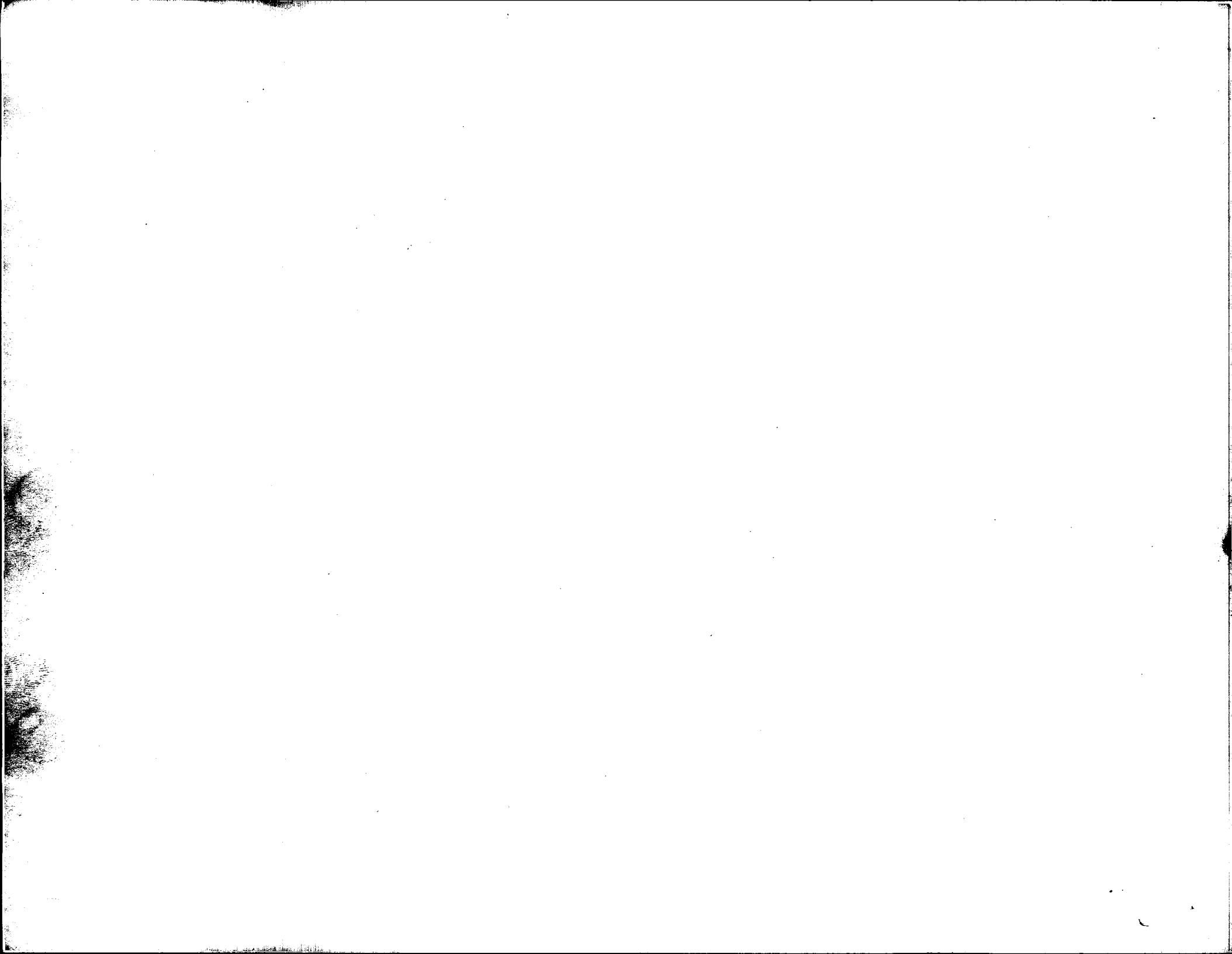
X First Article Prototype

Measured by:	<u>EP</u>	Audited by:	<u>JML</u>	Prototype Approval:	N/A
Date:	05/02/14	Date:	05/02/14	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	[Signature]

RELEASED

04.03.24 RF

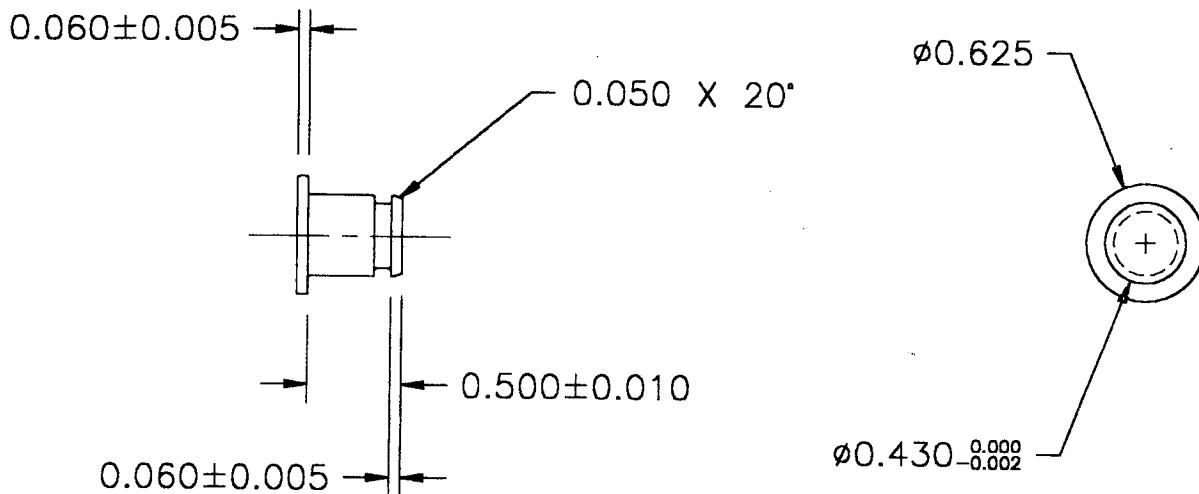




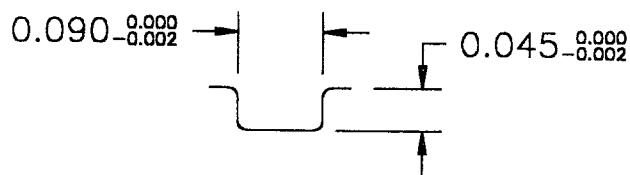
DESIGN <i>D101</i>	DRAWN BY <i>D101</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>D101</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	A DD Powder Coat, QSI 018 & QQ-A Specs.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSF 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

Powder Coat White (Ref. 43.5.1) per QSI 005 4.3

(B1)

PER QQ-A-225/7 (5052)
OR QQ-A-225/8 (6061)
OR QQ-A-225/1 (1100)
OR QQ-A-200/8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2594 PLUG ASSEMBLY INCLUDES: {1} D2594-1 PLUG
{1} D2594-3 O-RING ✓ IN ORDER
NO. 22381

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 07, 2005
03:58 pm

Work Order No	:	0022381	Department Code:		
Project Name	:	D2594-1	Burden Flags	:	NNNNNNN
Project For	:	WK512	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2594-1	Invoice Number	:	
Description	:	Plug	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	500	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	02-07-05	Est Margin	:	0.000%
Est Finish Date	:	03-15-05	Actual Margin	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
 Burden	 :	 0.00	 0.00	 0.00	
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00